

Work Order ID 58952

Thursday, May 20, 2010 10:34:04 AM



Page 1

Item ID: D2989-043

Accept



Setup Start



Revision ID:

Item Name: Basket Lid Assembly

Stop



Start Date: 5/26/2010 Start Qty: 1.00



Cust Item ID:

Required Date: 6/4/2010 Req'd Qty: 1.00



Customer:

Reference:

Approvals:

Process Plan:

Date: 10-5-20

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursDraw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

Draw Nbr

Revision Nbr

D2989

Rev D

100

0.00



Large Fab

Large Fab

Memo

0.00

Large Fab

1- assemble all ribs in DT9446 jig, weld as per dwg D2989
2- tack weld mesh on basket as per dwg D2989 using DT9446 jig
3- to locate hinges and shims use D2989-041, weld as per dwg D2989
A/R ER316 S.S. Rod Batch: 4113328

lpx 10.06.03
10/06/03

110

QC9- Inspect visual per QS1004- Fusion Welds

0.00



QC

Memo

0.00

Quality Control

① 10.06.03

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Dart Aerospace Ltd

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Cust Item ID:

Required Date: 6/4/2010 Req'd Qty: 1.00



Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
140	QC3- Inspect Part Finish	0.00							
QC	Memo	0.00							
Quality Control									
150	Identify as per dwg & Stock Location: <u>C-A</u>	0.00							
Packaging	Memo	0.00							
Packaging									
160	QC21- Final Inspection - Work Order Release	0.00							
QC	Memo	0.00							
Quality Control									

① BR06-7.ES 10/06/07 ①10/06/08 ②SMF
10-6-8.

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Picklist Print

Thursday, May 20, 2010 10:34:09 AM

Page 1

Work Order ID: 58952

Parent Item: D2989-043

Parent Item Name: Basket Lid Assembly









Comments: IPP Rev:I Removed D2989-041 05-11-03 JLM
IPP Rev:J 08-08-29 revC as per dwg DD verified by:EC
IPP Rev:K 08-09-24 plug holes prior to powder coating DD verified by:EC
IPP Rev:L 08-12-02 revD as per dwg DD verified by:

Start Date: 5/26/2010

Required Date: 6/4/2010

Start Qty: 1.00

Required Qty: 1.00

D2221-1	Manufactured	No	100	Each	23.0000	1		<i>SY 10/06/02</i>
								
Rib								
		<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>		
		WA		23				
		57182		1				
		57499		10				
		58122		12				
D2989-3	Manufactured	No	100	Each	2.0000	1		<i>B59034 ① SY 10/06/02</i>
								
Rib								
		<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>		
		WA		2				
		57995		2				
D2989-4	Manufactured	No	100	Each	2.0000	1		<i>SY 10/06/02</i>
								
Rib								
		<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>		
		WA		2				
		57996		2				
D2989-5	Manufactured	No	100	Each	6.0000	2		<i>58997W ① B59179 ② SY 10/06/02</i>
								
Rib								
		<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>		
		WA		6				
		57596		2				
		58061		4				

W/O:		WORK ORDER CHANGES					
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Page 2

Work Order ID: 58952



Parent Item: D2989-043



Parent Item Name: Basket Lid Assembly

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Required Date: 6/4/2010

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IPP Rev:K 08-09-24 plug holes prior to powder coating DD verified by:EC
IPP Rev:L 08-12-02 revD as per dwg DD verified by:

Start Qty: 1.00

Required Qty: 1.00

D3182-1 Manufactured No 100 Each 8.0000 2
 Hinge
② 10/06/02

	<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
	WA	8	
	57602	8	

D3442-3 Manufactured No 100 Each 12.0000 2
 Shim
② 10/06/02

	<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
	WA	12	
	53137	4	
	56204	8	

D3827-041 Manufactured No 100 Each 10.0000 1
 Rib Assembly (Inboard)
② 10/06/02

	<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
	WA	10	
	57219	4	
	57802	6	

D3832-5 Manufactured No 100 Each 5.0000 1
 Mesh (Lid)
① 10/06/02

	<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
	WA	5	
	57603	2	
	57941	3	

①

Thursday, May 20, 2010 10:34:09 AM

Shop Packet Print

Page 2

W/O:		WORK ORDER CHANGES					
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Page 3

Work Order ID: 58952



Parent Item: D2989-043



Parent Item Name: Basket Lid Assembly



Start Date: 5/26/2010

Required Date: 6/4/2010



Comments: IPP Rev:I Removed D2989-041 05-11-03 JLM
IPP Rev:J 08-08-29 revC as per dwg DD verified by:EC
IPP Rev:K 08-09-24 plug holes prior to powder coating DD verified by:EC
IPP Rev:L 08-12-02 revD as per dwg DD verified by:

Start Qty: 1.00



Required Qty: 1.00

D3833-5 Manufactured No 100 Each 15.0000 2
 Mesh (Lid End)  *Pl 10.06.02*

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
WA	15	
53722	9	
57627	6	

D3838-041 Manufactured No 100 Each 4.0000 1
 Rib Assembly (Basket Lid, LH)  *SY 10/06/02*

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
WA	4	
57831	2	
58059	2	

D3838-042 Manufactured No 100 Each 4.0000 1
 Rib Assembly (Basket Lid, RH)  *SY 10/06/02*

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
WA	4	
57832	2	
58060	2	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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NOTE: Date & initial all entries

D2989-043 BASKET LID ASSEMBLY
(MESH SHOWN LOCALLY FOR CLARITY)

D2989-041 BASKET LID ASSEMBLY
(MESH SHOWN LOCALLY FOR CLARITY)

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: POWDER COAT WHITE (4.3.5.2) PER DART QSI 005 4.3
BLACK ANTI-SKID PAINT AS INDICATED PER DART QSI 005 4.4
SPRAY PAINT INSIDE SURFACE BLACK PRIOR TO APPLYING ANTI-SKID
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: D2989-041 = 26.50 lbs; D2989-043 = 15.50 lbs
- 8) WELD PER DART QSI 004

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER

NO. 58952
PS10-5-20

ITEM	QTY -041	QTY -043	P/N	DESCRIPTION
1	X		D2989-041	BASKET LID ASSEMBLY
2		X	D2989-043	BASKET LID ASSEMBLY
3	1		D2506	LABEL PLATE
4	1		D2512-7	RIB
5	2		D2581	MOUNTING BRACKET
6		1	D2989-3	RIB
7		1	D2989-4	RIB
8		2	D2989-5	RIB
9	2		D2989-13	RIB
10	2	1	D2989-17	RIB
11	2		D2989-19	RIB
12		2	D3182-1	HINGE
13		2	D3442-3	SHIM
14		1	D3827-041	RIB ASSY (INBOARD)
15	1		D3832-3	MESH, BASKET LID
16		1	D3832-5	MESH, BASKET LID
17	2		D3833-3	MESH, LID END
18		2	D3833-5	MESH, LID END
19	1		D3836-041	RIB ASSY (BASKET LID, LH)
20	1		D3836-042	RIB ASSY (BASKET LID, RH)
21		1	D3838-041	RIB ASSY (BASKET LID, LH)
22		1	D3838-042	RIB ASSY (BASKET LID, RH)
23	1		D3852-041	RIB ASSEMBLY
24	1		D3852-042	RIB ASSEMBLY

RELEASED
08/11/16

D	REVISED -041/-043 PARTS LISTS AND ADDED "ITEM" COLUMN TO PARTS LIST (2N D3-1); D3836-041 REPLACES D2989-9/-15; D3836-042 REPLACES D2989-10/-15; D3836-041 REPLACES D2989-1/-7; D3836-042 REPLACES D2989-2/-7; D3852-041 REPLACES D2989-11; D3852-042 REPLACES D2989-2; REMOVED D327-3 (NOW INSTALLED ON D3836 DWG); D2989-9/-10 (NOW ON D3836 DWG); D2989-11/-12 (NOW ON D3836 DWG) AND D2989-11/-12 (NOW ON D3852 DWG). REASON: TO SATISFY "LEAN MANUFACTURING" PROGRAM	MB	08.09.24
C	FRAME MATERIAL WAS 0.060 WALL; MESH MATERIAL UPDATED; DRAWING TRANSFERRED TO "B" FORMAT AND CURRENT DRAFTING STANDARD	AJS	08.06.20
B	ADD SHIM UNDER HINGES, UPDATE LID DIMENSIONS	PH	05.06.07
A	NEW ISSUE	DS	00.10.27
REV.	DESCRIPTION	BY	DATE
DESIGN	DS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN		DRAWING NO. D2989	REV. D
CHECKED			SHEET 1 OF 5
MFG. APPR.		TITLE BASKET LID ASSEMBLY	SCALE NTS
APPROVED		COPYRIGHT © 2006 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	
DE APPR.		DATE 08.09.24	

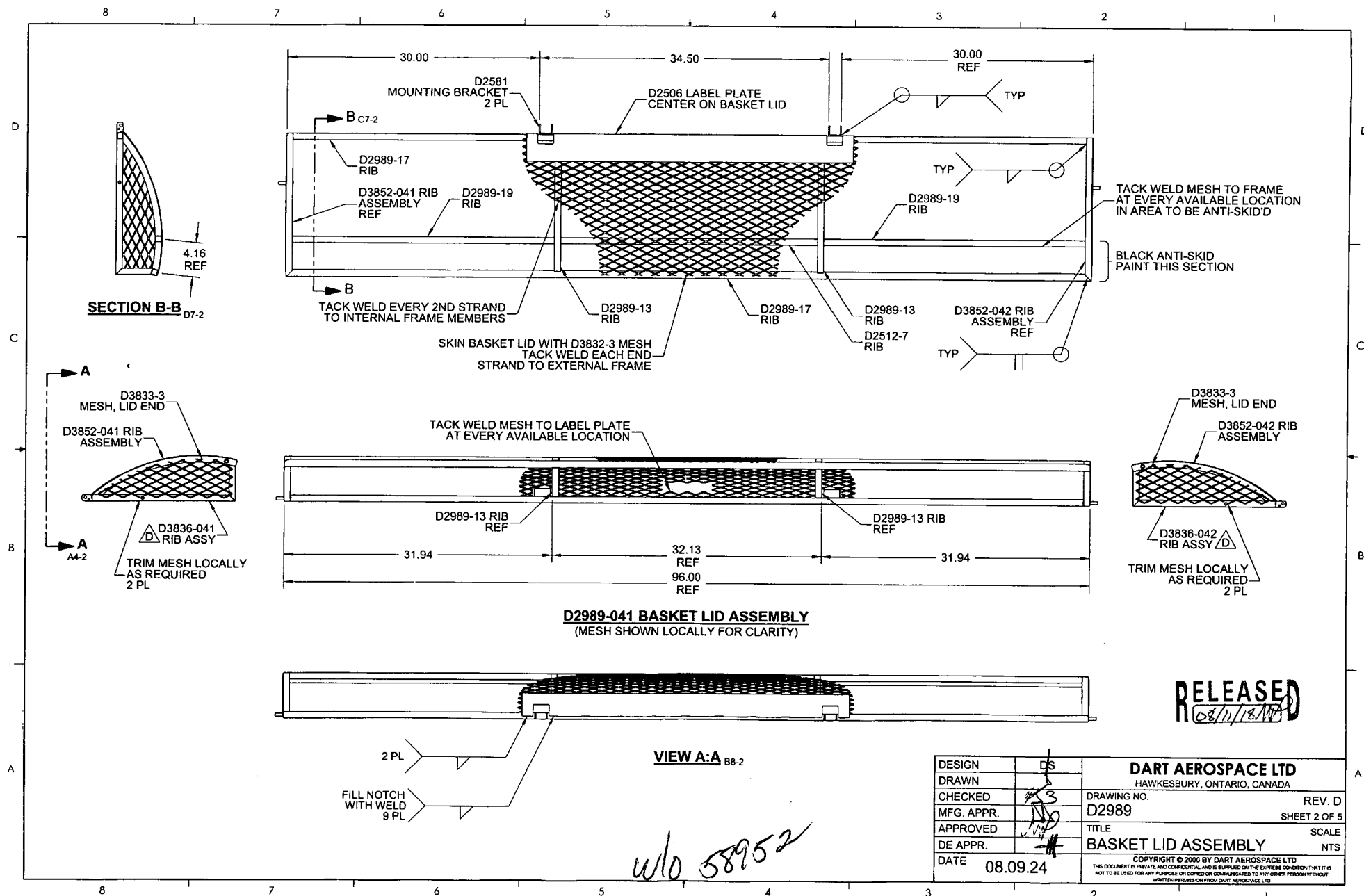
W/O:		WORK ORDER CHANGES					
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NOTE: Date & initial all entries



Dart Aerospace Ltd

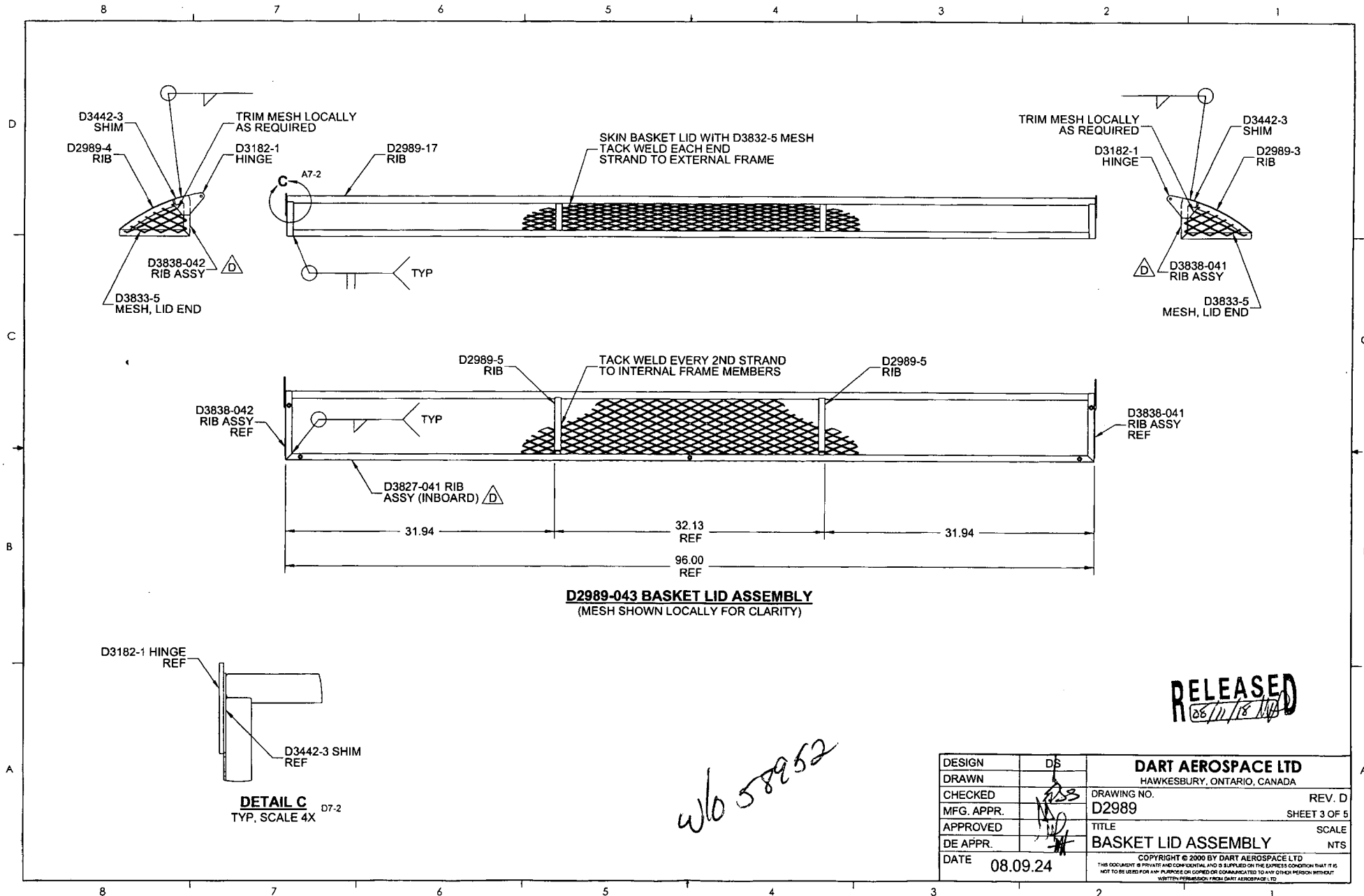
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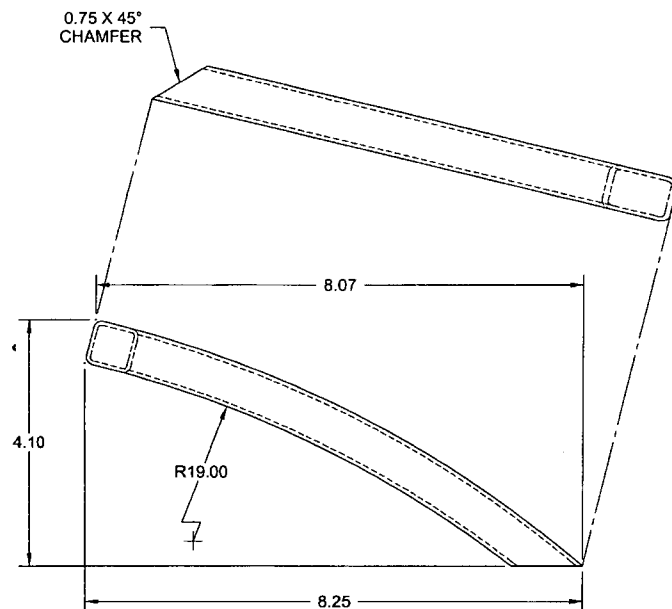
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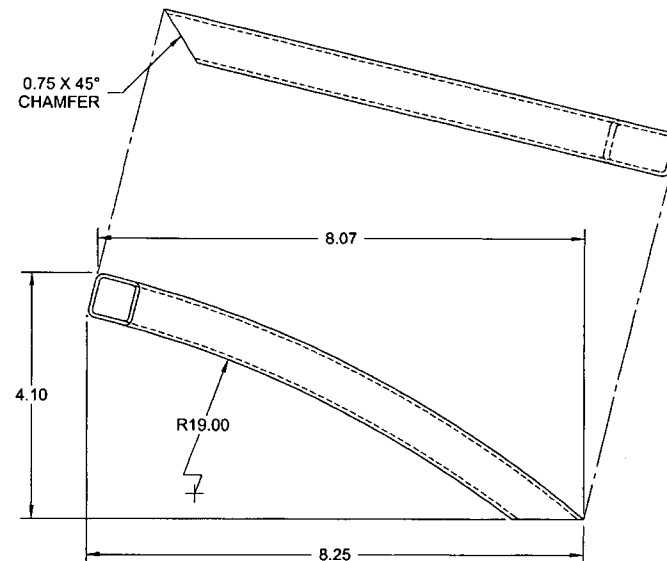
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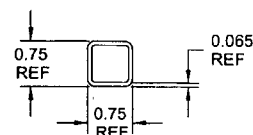


D2989-3 RIB



D2989-4 RIB

w/0 58952



TYPICAL SECTION VIEW

- NOTES:**
- 1) MATERIAL: D3166-3 BASKET HOOP
 - 2) FINISH: NONE
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: N/A
 - 7) WEIGHT: D2989-3/4 = 0.39 lbs;

RELEASED
08/11/18

DESIGN	DS	DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. D
MFG. APPR.		D2989	SHEET 4 OF 5
APPROVED		TITLE	SCALE
DE APPR.		BASKET LID ASSEMBLY	NTS
DATE	08.09.24	<small>COPYRIGHT © 2000 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR CORRECTED OR DISSEMINATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	

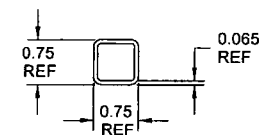
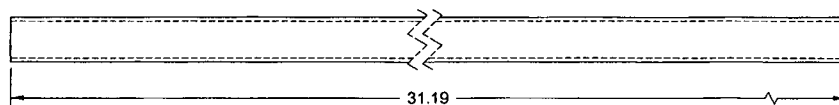
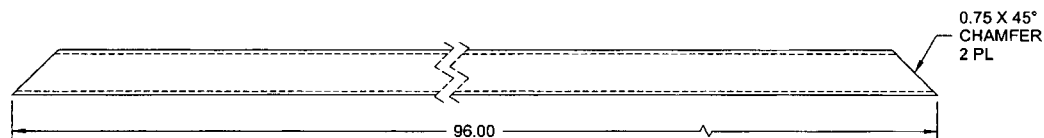
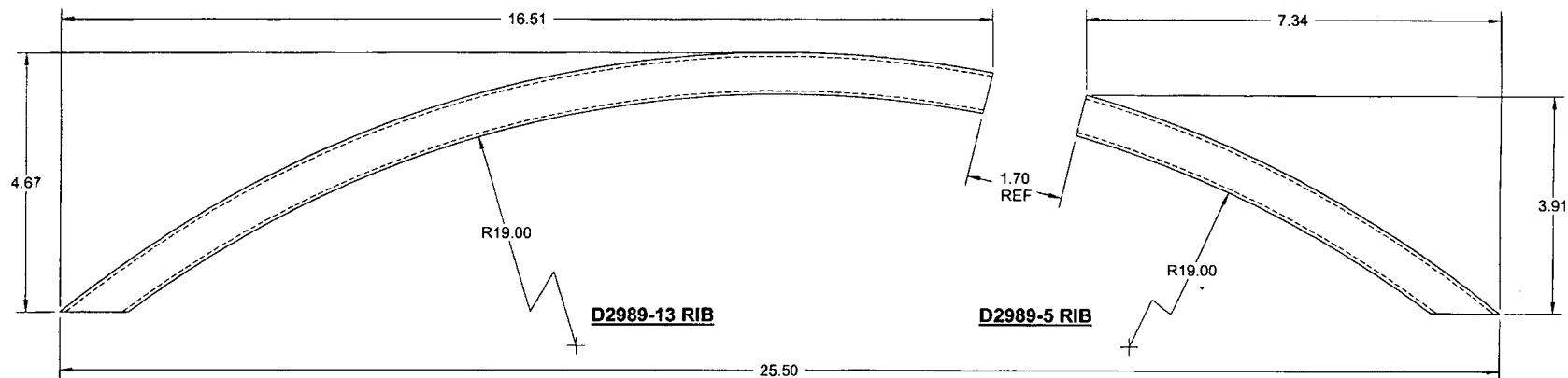
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**TYPICAL SECTION
VIEW**

NOTES:

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL SQUARE TUBE, 0.75 X 0.75 X 0.065 WALL
REF. DART SPEC. M304TS0.750W0.065
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 8) WEIGHT: D2989-5 = 0.37 lbs; D2989-13 = 0.81 lbs; D2989-17 = 4.57 lbs; D2989-19 = 1.50 lbs

u/o 58952

RELEASED
08/11/18

DESIGN	DS	DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED	<i>[Signature]</i>	DRAWING NO.	REV. D
MFG. APPR.		D2989	SHEET 5 OF 5
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.		BASKET LID ASSEMBLY	NTS
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